Work Orde Tuesday, August												,	Page 1
Item ID: Revision ID:	D3910-3			A	Accept					Setup	Start		
	Crosstube Lug 8/31/2010 9/7/2010	Start Qty: 10. Req'd Qty: 10.			4	Cust Item I Customer:	D:				Stop		
Reference: Approvals:	Process Pla	an:/	Date:	10-8-31	Tooling: SPC (Y/N):		nte:	_			Start Stop		1110 181 1818 1818 1818 1818 1818 1888
Sequence ID/ Work Center II	)	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr		vision Nbr									ن		
100 Bandsaw Jeaspa Bandsaw	В	<b>Memo</b> Cut to 1	1.450" Long□		0.00	810/09/19	•		16	B			
HAAS 1	machine #1	<b>Memo</b> MACH FOLIO DWG F		JO FA865 ANE	0.00 0.00 DWG H. A	10/09/21			/0		Ø.		

DEBURR

Dart Ae	rospace	e Ltd								
W/O:			WC	RK ORDER CHANG	BES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes N	o <b>DQ</b> /	A:	Date:	
	R	esolution:	Disposition	າ:	QA:	N/C Clos	sed:	<del></del>	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)				
D.4.T.P.	0.755	Description of NC		Corrective Action Sec	tion B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector

Section A Initial Chief Eng Chief En

#### Work Order ID 61703

Tuesday, August 31, 2010 1:19:51 PM



Page 2

Item ID:

D3910-3

Accept



Setup Start



Stop

**Revision ID:** Item Name:

**Start Date:** 

Crosstube Lug

8/31/2010

**Start Qty: 10.00** 

Required Date: 9/7/2010

Req'd Qty: 10.00



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

**Approvals:** 

Process Plan:

Date:

**Tooling:** 

Date:

Tool # Plan

Run Start

Number Stamp

Date:\_\_\_\_\_

SPC (Y/N):

Date:

Stop

Reject

Insp.

Sequence ID/ **Work Center ID** 

120

Quality Control

Operation **Description** 

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/ **Run Hours** 

0.00

10/09/21

Qty Code

Qty

Accept

Reject

130

140

QC8- Inspect parts - second check

Memo

and 10/09/22 0.00 Sel 10-9-23

10 8

Quality Control

Chemical Conversion Coat per QSI005 4.1

HandFinish Hand Finishing

Memo

0.00

W/O:			W	ORK ORDER CHANG	GES	<del></del>			<u> </u>
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									,
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR	)			
DATE	OTED	Description of NC			ction B Verification			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC inspector
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#### Work Order ID 61703

Tuesday, August 31, 2010 1:19:51 PM



Page 3

Item ID:

D3910-3

**Revision ID:** 

Item Name: Crosstube Lug

**Start Date:** 

8/31/2010

Required Date: 9/7/2010

**Start Qty: 10.00** Req'd Qty: 10.00



Accept

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

QC:

Date: \_\_\_\_\_

Date: **Tooling:** 

**SPC (Y/N):** 

Date:

Date:

Tool # Plan

Accept

Reject

Run

Setup Start

Stop

Start

Stop

Reject Insp.

**Work Center ID** 150

Sequence ID/

Powdercoat

Powder Coating

**Operation** Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M 115091 START 7:43

Memo

OUTN. T: 3200

Fix 15478:15

Set Up/

Run Hours 10-9-27. 0.00

Tool ID

Code

Qty

Qty

Number

Stamp

160

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

-7 9U 10/09/22

170

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

Kilofypr (w)

Packaging

	•								t
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _	
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DATE	STEP	Description of NC			tion B	Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		tion C	Chief Eng	QC Inspector
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Work Ord Tuesday, Augus												Page 4
Item ID: Revision ID: Item Name:	D3910-3 Crosstube Lug	,		Accept					Setup	Start Stop		
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Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ite:	_		Run	Start Stop		
Sequence ID/ Work Center II 180 QC Quality Control	D	Operation Description QC21- Final Inspection -  Memo	Work Order Releas	Set Up/ Run Hours e 0.00	Tool ID	Tool #	Plan Code	Accep Qty	Qt:			Insp. Stamp

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W/O:			WO	RK ORDER CHANG	ES			
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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## **Picklist Print**

Tuesday, August 31, 2010 1:19:54 PM

Work Order ID: 61703

Parent Item: D3910-3

Parent Item Name: Crosstube Lug



**Start Date: 8/31/2010** 

Required Date: 9/7/2010

Page 1

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	364.5171	0.13	1.368421 L	10/09	/19	
				<b>Location</b>		Loc	<u>Oty</u>	Loc Code					
				MAT06		364.5170	0795						

	-									
W/O:			WC	ORK ORDER CHANC	GES		· ·			1
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Y	es No	DQA:		Date: _	
Resolution:			Dispositio	n:	QA: N/C	Clos	ed:		Date: _	
NCR:		1	WORK ORD	ER NON-CONFORM	ANCE (N	CR)				
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DART AEROSPACE LTD	Work Order:	41703
Description: Crosstube Lug	Part Number:	D3910-3
Inspection Dwg: D3910 Rev: B		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments	
Dimension	lolerance	Dimension	Accept	Kejeci	Inspection	Comments	
4.45	+/-0.030	4,450	~		Vern	GA-01	
1.38	+/-0.030	1.381	V		3 f	. (	
R0.080	+/-0.020	RO.063	<b>✓</b>		Rad Bage	ref.	
0.27 Ref	+/-0.030	0.278	/		Height Gage Vein	31006	
0.31	+/-0.030	0.304	<b>&gt;</b>		Vein	GA-01	
0.735 Ref	+/-0.010	6.743	<b>&gt;</b>		( )	1 /	
R1.20	+/-0.030	R1.200	<b>✓</b>		Rad Gage	788	
3.700	+/-0.010	3.700	<b>V</b>		Vein	6A-01	
0.375	+/-0.010	0.376	\		5 /	17	
0.625	+/-0.010	0.625	<b>~</b>		1 /	1 /	
0.375	+/-0.010	0.377	<b>&gt;</b>		11	17	
R0.34	+/-0.030	RO340	<b>V</b>		Rad Gage	ref	
Ø0.257	+0.006/-0.001	\$0.258	<b>\</b>		Vein	GA-01	
0.100 x 45°	+/-0.010 x +/-0.5°	0.109 x450	~		1.	17	
1.41 Ref	+/-0.030	1.404	>	. • 1.	Height Gage	31006	
					0 3		

Measured by: ガ, A	Audited by:	and	Preliminary Approval:	
Date: 10/09/21	Date:	10/09/22	Date:	

Rev	Date	Change	Revised by (	Approved
Α	10.04.20	New Issue	KJ 99	

W/O:			WC	ORK ORDER CHANG	ES					
DATE	DATE STEP PR			CEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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DATE	STEP	Description of NC Section A			ion B	Verific	cation	Approval	Approval	
DATE			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector	

SHOP COPY RETURN FO ENGINEERING UNCONTROLLED CO SUBJECT TO AMENDMES WITHOUT NOTICE

D3910-3

**D3910-3 X-TUBE LUG** 

Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-807-2 10.03.16 Α NEW ISSUE JPH 10.03.04 DATE REV. DESCRIPTION BY DESIGN DART AEROSPACE LTD JPH DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. D3910 MFG. APPR. APPROVED TITLE X-TUBE LUG (350)

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THIS DOCUMENT IS PROVIDED AND ADDRESS OF CONTINUE AND THE SUPPLIES A DE APPR. DATE 10.03.16

03010-1

**D3910-1 X-TUBE LUG** 

NOTES:

1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
0.005 1.005 1.005 1.005 OF 0.015 ± 0.005

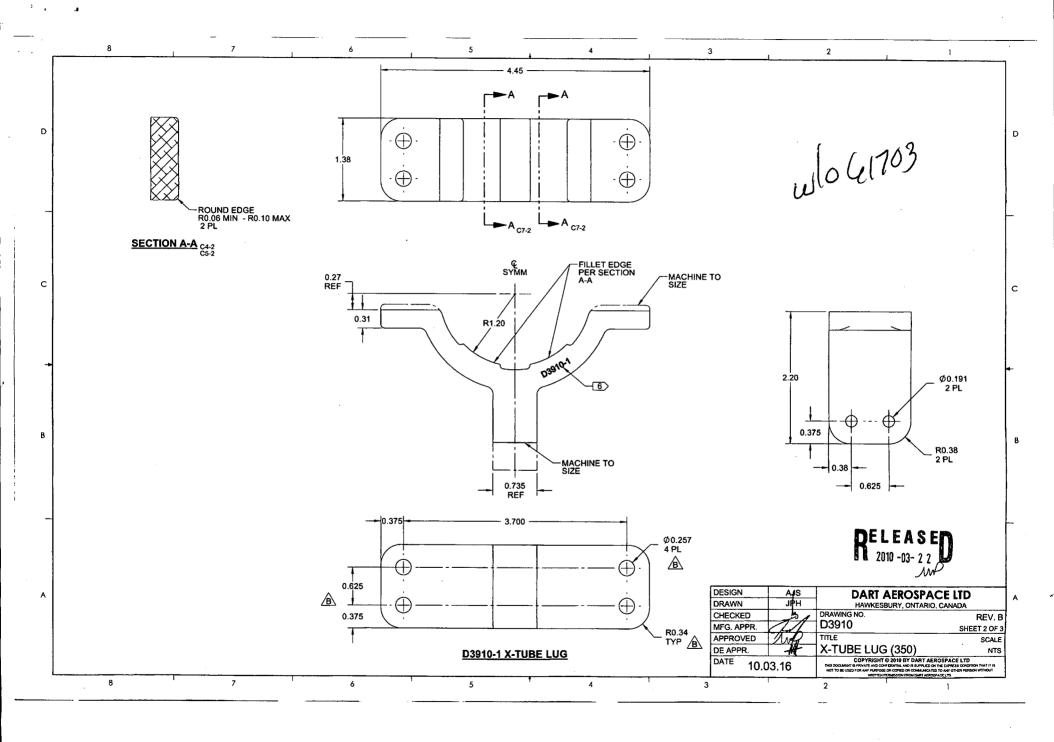
7) WEIGHT -1: 0.32 lbs

-3: 0.25 lbs

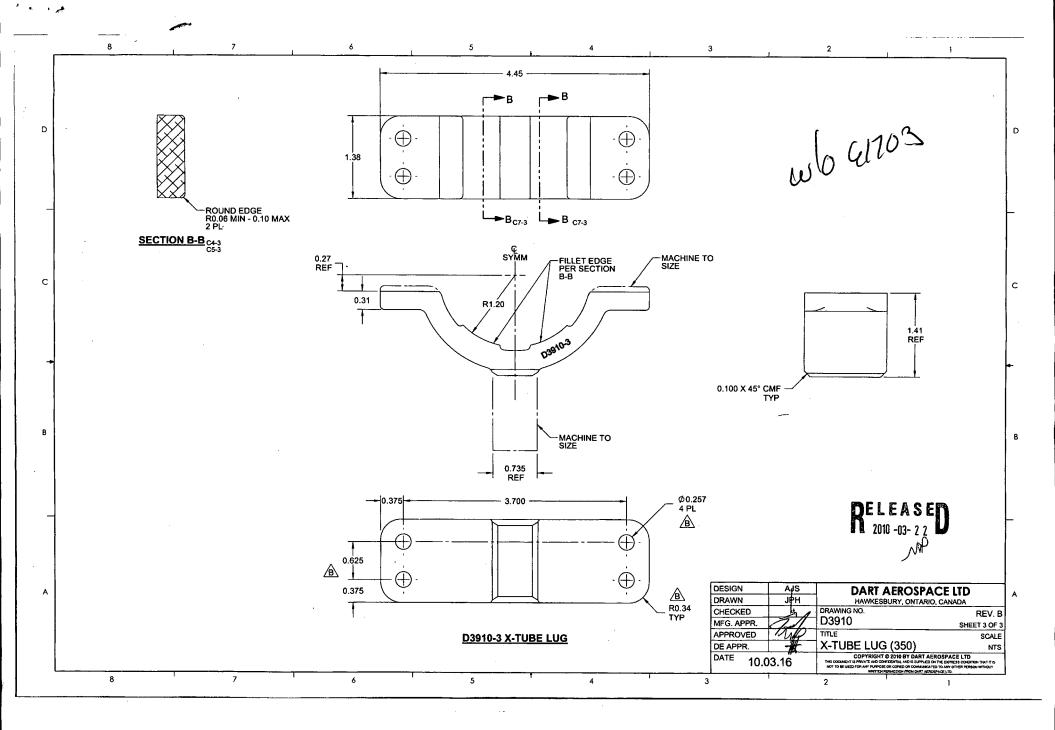
SHEET 1 OF 3

REV. B

Dart Ae	ospace	e Ltd								,
W/O:			W	ORK ORDER CHA	NGES					
DATE	STEP	PRO	OCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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